

Work Order ID 58057

April 22, 2010 11:57:06 AM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:						
Item Name:	350 Basket Base				Stop	
Start Date:	22/04/2010	Start Qty:	1.00			
Required Date:	30/04/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-4-22	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
	Large Fab								
	Memo	0.00							
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221								
	2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221								
	3- tack weld mesh on basket as per dwg D2221								
	A/R ER316 S.S. Rod Batch: 111679								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
	Memo	0.00							
	Quality Control								

04.01
10.05.08

10.06.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58057

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Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 22/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 10106101



130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

2) 10106104

1

0

1ST COAT:

START TIME: 8:45am

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:15am

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 10:00am

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:30am

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 30/04/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	QC3- Inspect Part Finish	0.00							
									
QC	Memo	0.00							
Quality Control									

Ep 510/06/07 @

150	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
									
Packaging	Memo	0.00							
Packaging									

w/p 58942

Ep 510/06/07 @

160	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

10606/07

*MF
10-6-7*

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Picklist Print

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Page 1

Work Order ID: 58057

Parent Item: D2221

Parent Item Name: 350 Basket Base

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 22/04/2010

Required Date: 30/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 3.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

3

57182

3

D2221-5

Manufactured No

100 Each 10.0000 2.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

10

56203

2

57500

8

D2221-7

Manufactured No

100 Each 9.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

9

56202

1

57501

4

57805

4

Pl 10.05.28

B57499 → ①

Pl 10.05.28

②

Pl 10.05.28

①

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No 100 Each 16.0000 2.0000



Basket Hinge

Pl 10-05-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

16

57502

10

57793

6

2

D2235-1 Manufactured No 100 Each 4.0000 2.0000



Basket Rib

Pl 10-05-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

4

57593

4

357792 → 2

D2581 Manufactured No 100 Each 37.0000 2.0000



Mounting Bracket

Pl 10-05-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

37

46086

2

51745

2

57185

33

358301 → 2

April 22, 2010 11:57:13 AM

Shop Packet Print

Page 2

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 22/04/2010

Required Date: 30/04/2010

Start Qty: 1.00

Required Qty: 1.00

* D3442-1 Manufactured No 100 Each 18.0000 2.0000
Shim

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

18

56579

18

* D3825-041 Manufactured No 100 Each 4.0000 2.0000
Rib Assembly (Basket End)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

4

57401

4

* D3826-041 Manufactured No 100 Each 4.0000 2.0000
Rib / Gusset Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

4

57432

4

Cpl 10.05.28

(2) Cpl 10.05.28

358025 → (2)

Cpl 10.05.28

57835 → (2)

April 22, 2010 11:57:13 AM

Shop Packet Print

Page 3

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00



D3827-041

Manufactured No

100

Each

6.0000

1.0000



Rib Assembly (Inboard)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

6

57219

6

100

Each

1.0000

1.0000

D3832-1

Manufactured No



Mesh (Base)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

1

57280

1

100

Each

3.0000

2.0000

D3833-1

Manufactured No



Mesh (Base End Face)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

3

56396

1

57594

2

Pl10.05.28

B57802 → ①

Pl10.05.28

B57791 → ①

Pl10.05.28

B57834 → ①

April 22, 2010 11:57:13 AM

Shop Packet Print

Page 4

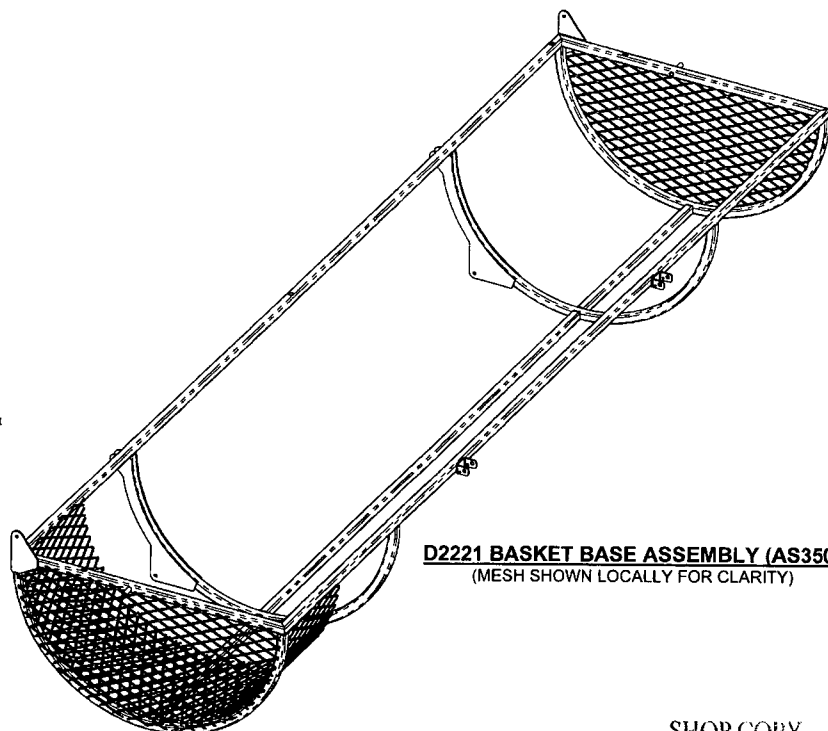
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58057

BS10-4-22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/SI-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

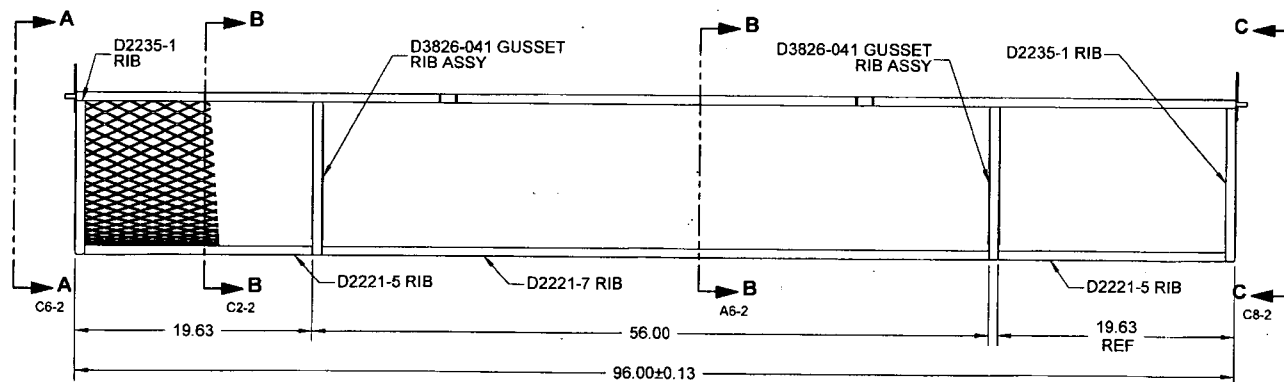
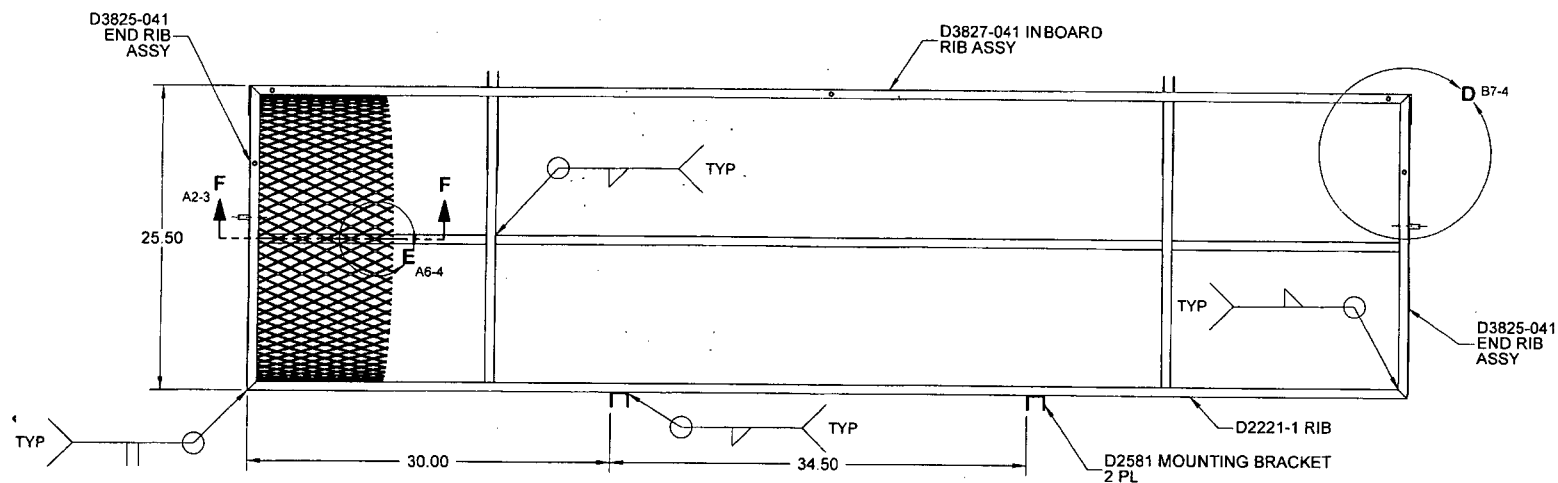
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

W/O 58057

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18.	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

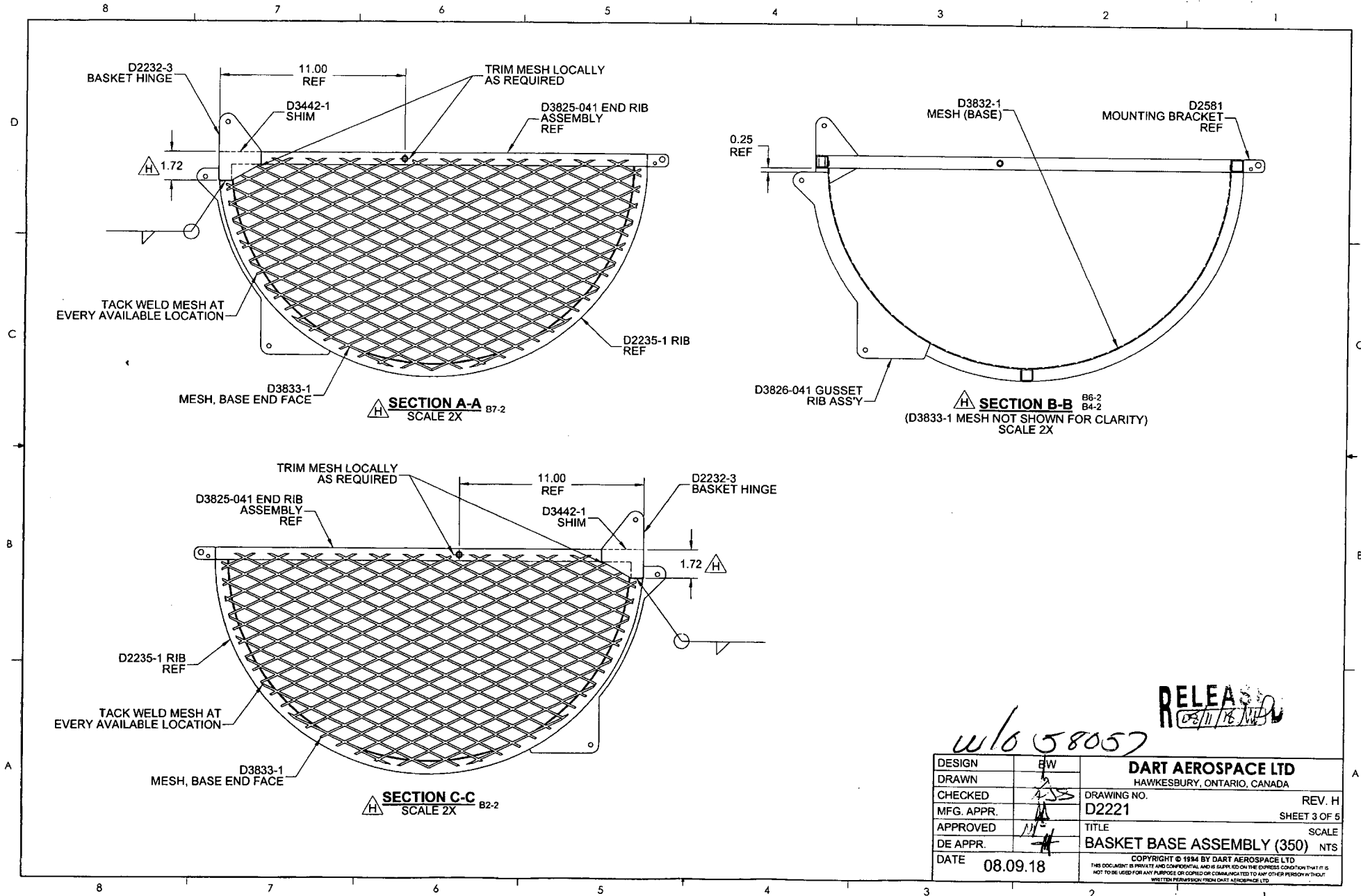
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DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4-3-3	DRAWING NO.	REV. H
MFG. APPR.	1	D2221	SHEET 3 OF 5
APPROVED	1/1	TITLE	SCALE
DE APPR.	1	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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8 7 6 5 4 3 2 1

D

C

B

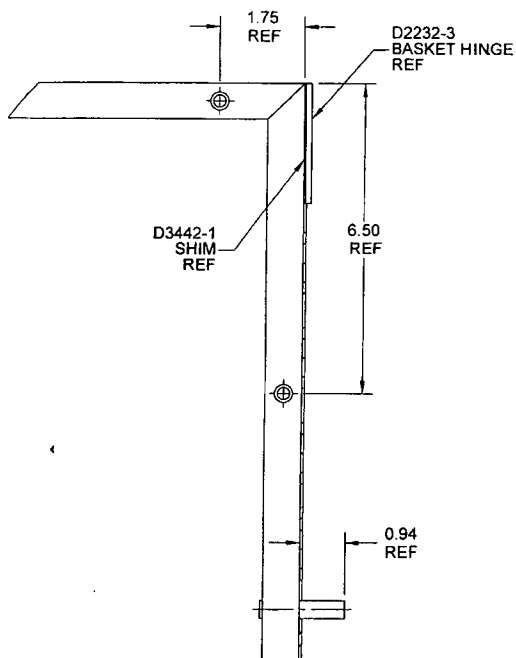
A

D

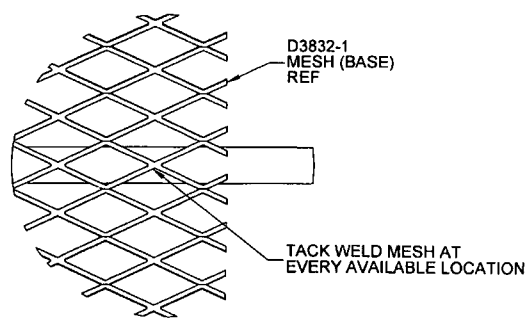
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B

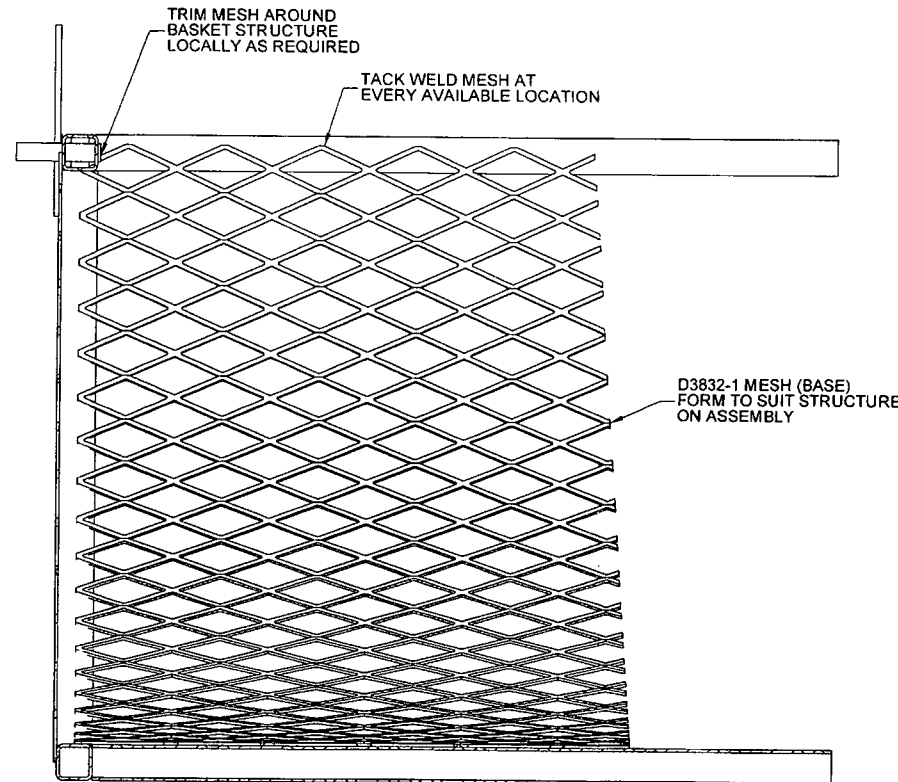
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DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2



SECTION F-F
SCALE 4X D7-2

RELEASED
02/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	14/8	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	11/8	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1

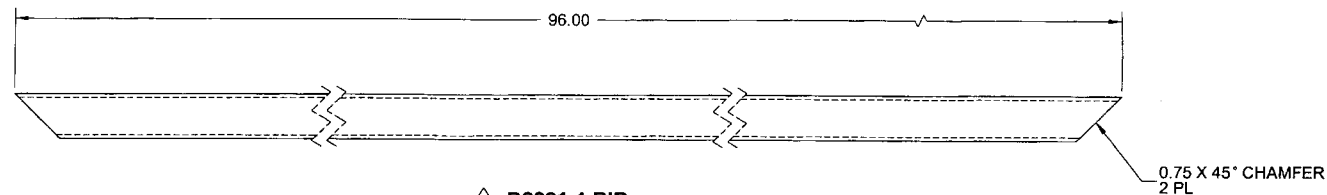
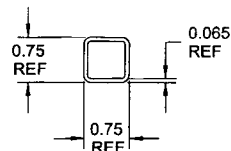
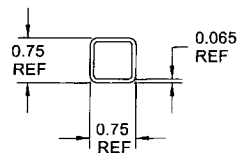
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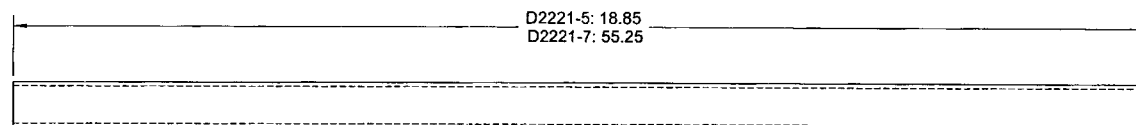
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NOTE: Date & initial all entries



D2221-1 RIB



D2221-5/-7 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED
08/10/18 WJ

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D2221	REV. H
MFG. APPR.	MD		SHEET 5 OF 5
APPROVED	M	TITLE	SCALE
DE APPR.	CH	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries